

Date: Thursday, 16/11/2006 9:18:49 AM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE
Job Number	: 29402		
Estimate Number	: 10910		
P.O. Number	: <i>N/A</i>	Part Number	: D33631
This Issue	: 16/11/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3363 REV. B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision	: B1
Previous Run	: 29402	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/12/2006 Qty: 4 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: B 05.09.09 Remove c'sink rivet holes and add welding stepK J/JLM Est: C 06.11.15 waterjet * EC		

## Additional Product

Job Number:








Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet
	Comment: Qty.: 2.4150 sf(s)/Unit Total : 9.6600 sf(s) 6061-T6 .063 thick aluminum Sheet Batch: <i>m19326</i> <i>ml 06 11 23</i> (4)	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3363 Dwg Rev: <i>B1</i> <i>ml 06 11 23</i> (4) Prog Rev: <i>B1</i> 2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>ml 06 11 23</i> (4) (PTO)	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK <i>06/11/23</i> (4)	
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Deburr Form as per Dwg D3363 <i>FF 06-11-27 4</i> <i>SB 06/11/27 4</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/23	3	- 1 part scrap - part moved in water jet when being cut		Scrap + replace	 06/11/23	 06/11/23	 06/11/23	 06/11/23

NOTE: Date & initial all entries

Date: Thursday, 16/11/2006 9:18:50 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE

Job Number: 29402

Part Number: D33631

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/28 (4)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using DT8790 as per Dwg D3363 and QSI 004

06/11/28 (7)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/11/28 (4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/28 (4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

06/11/28 (4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



06/11/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

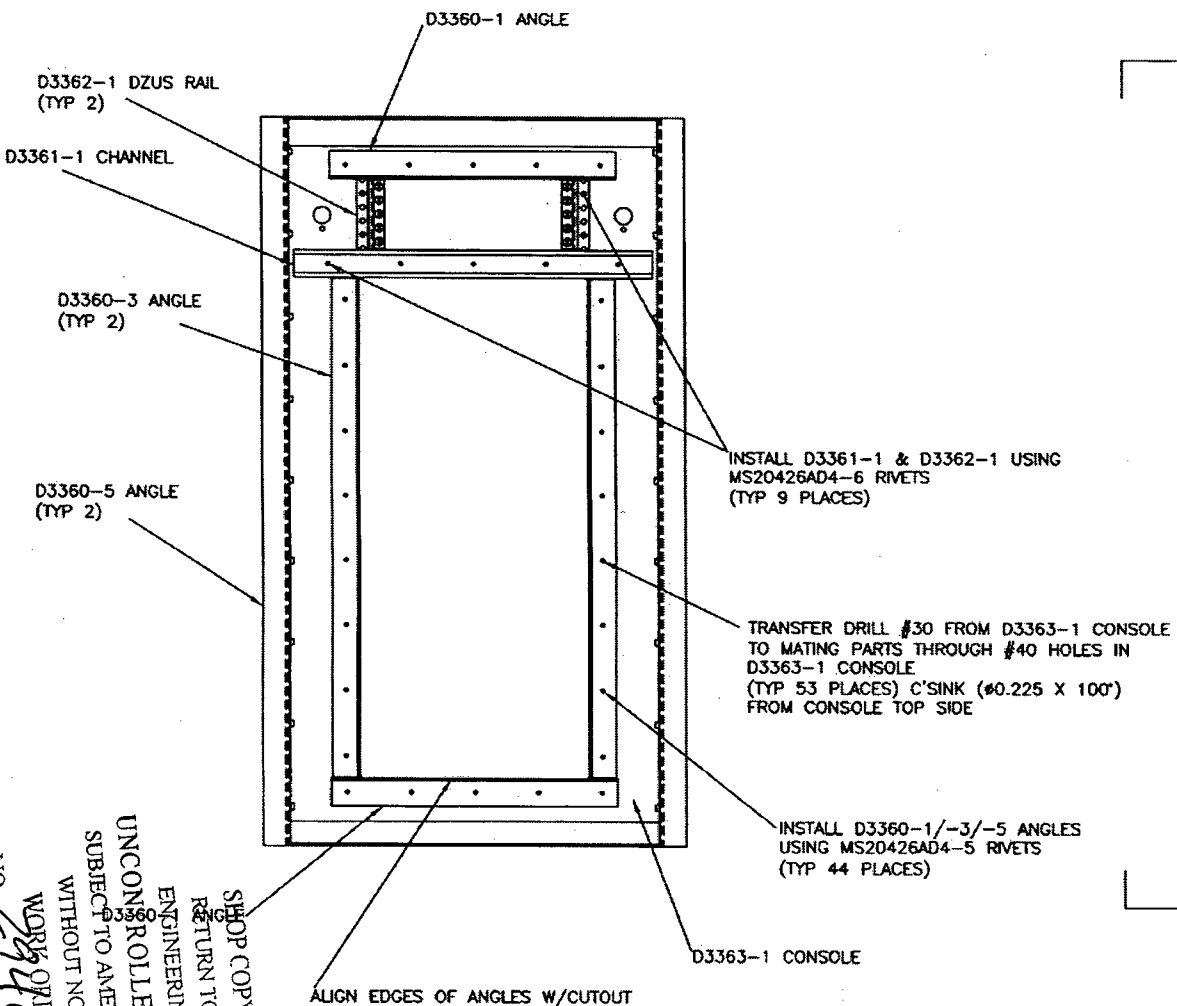
**DART**

RELEASED

05-03-31

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA	SHEET 1 OF 3
DATE	05.03.28	TITLE	D3363	CONSOLE ASSEMBLY	SCALE 1:5
A	04.11.29	NEW ISSUE			
B	05.03.28	INCREASE WIDTH BY 0.125			
B1	05.07.28	CHANGE WIDTH TO 10.930, WAS 10.93			

C'SINK  
THIS SIDE  
(REF)



**PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY**

**VIEW A-A FROM UNDER CONSOLE ASSEMBLY**

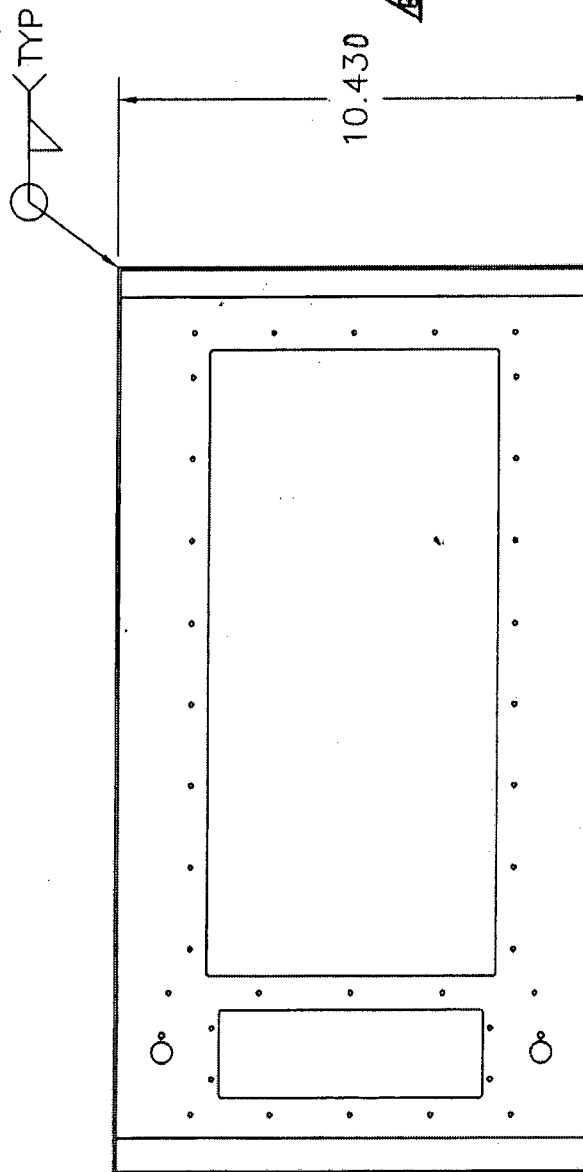
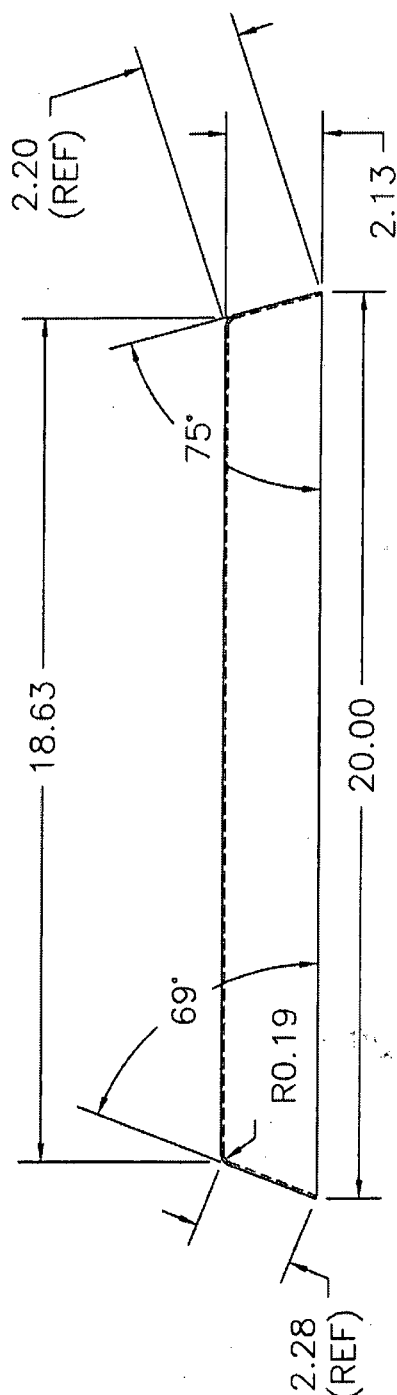
**D3363-041 CONSOLE ASSEMBLY**

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH:ACID ETCH AND ALODINE PER DART QSI 005 4.1

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WITHOUT NOTICE  
WORK ORDER  
24402

**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. B SHEET 2 OF 3
DATE 05.03.28		TITLE CONSOLE ASSEMBLY	SCALE 1:4



**D3363-1 BEND DETAIL**

**RELEASED**

05-03-31 *[Signature]*

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NO. **29402**

**D3363-1 CONSOLE**

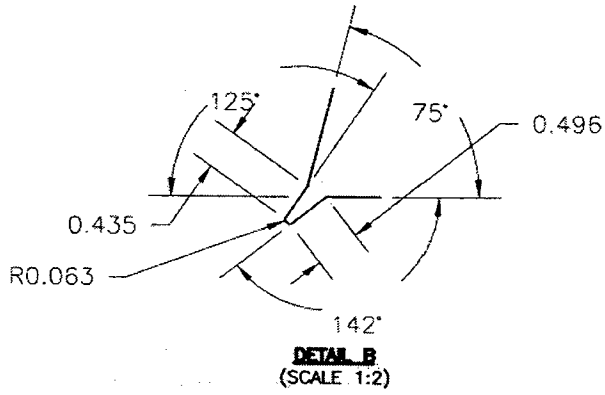
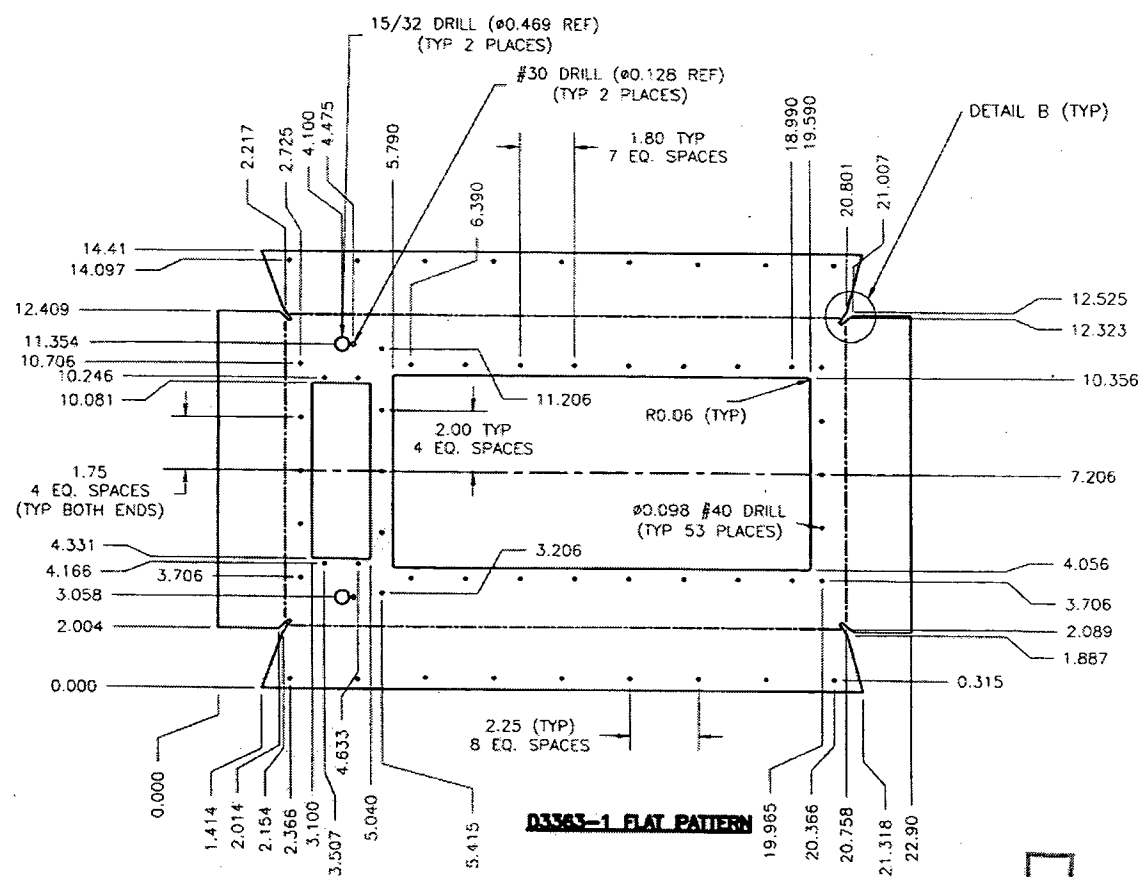
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. B
DATE	05.03.28			D3363	SHEET 3 OF 3
				TITLE	SCALE
				CONSOLE ASSEMBLY	1:6



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05.03.31

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WORK ORDER  
NO 24402

**D3363-1 CONSOLE (FLAT PATTERN)**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (MATERIAL SPEC: QQ-A-250/11) 0.063 THICK (REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 29402
<b>Description:</b> Console		<b>Part Number:</b> D3363-1
<b>Inspection Dwg:</b> D3363 Rev: B1		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
22.90	+/- 0.030	22.90	✓		Measuring tape	
14.41	+/- 0.030	14.40	✓		Measuring tape	
4.056	+/- 0.010	4.056	✓		VERN	
10.356	+/- 0.010	10.354	✓		VERN	
Ø 0.128	+0.005 - 0.001	0.130	✓		VERN	
Ø 0.098	+0.004 - 0.001	0.102	✓		VERN	
2.25	+/- 0.030	2.25	✓		VERN	
3.206	+/- 0.010	3.201	✓		VERN	
1.80	+/- 0.030	1.795	✓		VERN	
1.75	+/- 0.030	1.75	✓		VERN	
Ø 0.469	+0.006 - 0.001	0.470	✓		VERN	
4.331	+/- 0.010	4.331	✓		VERN	
10.081	+/- 0.010	10.085	✓		VERN	
3.100	+/- 0.010	3.102	✓		VERN	
3.058	+/- 0.010	3.053	✓		VERN	
11.354	+/- 0.010	11.349	✓		VERN	
4.475	+/- 0.010	4.465	✓		VERN	

<b>Measured by:</b> MC:MM	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>
<b>Date:</b> 06/11/23	<b>Date:</b> 06/11/23	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	